



Dart Aerospace Ltd.
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D2857-1**Job Sheet 198453****Part No:** D2857-1**Job Qty:** 20 pcs**Part Name:** Hinge Bracket**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 7/30/19**Job Tracking No:****Due Date:** 8/19/19**Created By:** Marie Lajeunesse**Type:** SOLD *SFL***Description:****Note:** DWG REV C IPP C 00.06.22 Removed P/O for powder coat EC IPP D**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	20 pcs	8/19/19	8/19/19	0.00	0.69	Bandsaw - 1		<i>SBL 19/09/16</i>
110	HAAS 4 Axis - B4B	20 pcs	8/19/19	8/19/19	0.13	11.07	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		<i>SBL 19/09/16</i>
							HAAS - 4 - B4B		
130	QC 8	20 pcs	8/19/19	8/19/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		<i>amk 19/09/16</i>
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		

**Container No:** S213960**Part:** D2857-1**Job No:** 198453**Serial No/Batch:** S213960**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

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Date: 08/16/19

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140	Handfinish - 1-1 Chemical-B4B	20 pcs	8/19/19	0.00 0.44	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	SEP 17 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
160	Powdercoat - 1 White GI(A)-B4B	20 pcs	8/19/19	0.00 0.30	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BR 19-9-18
					Powdercoat - 4 - B4B	
170	QC 3	20 pcs	8/19/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	

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				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	20 pcs	8/19/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	SEP 24 2019
				QC 21 - SA - 53	

DAS

70

9-89

Part Op 100 - (Bandsaw) Cut blanks 4.425"
 Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FA940 DWG REV: C 2-Deburr any rough edges
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ FINISH TIME: _____
 170 - (QC3- Inspect Part Finish)
 180 - (Identify as per dwg & Stock Location: _____)
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.250X2.000	6061T6 Bar 1.250 X 2.000	7.4000 ft (.37 ea)	100-Bandsaw - 1	5202769

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.250X2.000	7	8	0

GAVE Chemical
to over.

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Bracket	4.300inches $\pm$ 0.010	4.310 4.290	4,299	
2	Hinge Bracket	4.000inches $\pm$ 0.010	4.010 3.990	3,999	
3	Hinge Bracket	0.340inches $\pm$ 0.010	0.350 0.330	,337	
4	Hinge Bracket	1.110inches $\pm$ 0.005	1.115 1.105	1,110	
5	Hinge Bracket	1.790inches $\pm$ 0.010	1.800 1.780	1,788	
6	Hinge Bracket	1.320inches $\pm$ 0.005	1.325 1.315	1,320	
7	Hinge Bracket	2.000inches $\pm$ 0.010	2.010 1.990	2,001	
8	Hinge Bracket	0.340inches $\pm$ 0.010	0.350 0.330	,337	
9	Hinge Bracket	0.447inches $\pm$ 0.010	0.457 0.437	,446	
10	Hinge Bracket	0.171inches + 0.005 - 0.000	0.176 0.171	,173	
11	Hinge Bracket	0.147inches $\pm$ 0.010	0.157 0.137	,146	
12	Hinge Bracket	0.376inches $\pm$ 0.010	0.386 0.366	,380	
13	Hinge Bracket	0.126inches $\pm$ 0.010	0.136 0.116	,126	
14	Hinge Bracket	0.063inches $\pm$ 0.010	0.073 0.053	,064	
15	Hinge Bracket	0.166inches + 0.005 - 0.000	0.171 0.166	,166	
16	Hinge Bracket	0.911inches $\pm$ 0.010	0.921 0.901	,911	
17	Hinge Bracket	0.600inches $\pm$ 0.010	0.610 0.590	,600	
18	Hinge Bracket	0.125inches $\pm$ 0.010	0.135 0.115	,129	
19	Hinge Bracket	0.150inches $\pm$ 0.010	0.160 0.140	0,149	

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